

Work Order ID 84860

84860

Monday, May 28, 2012 11:15:07 AM

Ship to day Page 1

Item ID: D412-698-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hinge Panel Automatic Door Opener, LH (Standard)

Stop

NS2

Start Date: 5/28/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *ME*

Date: *12-05-28*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9548

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-698-041 CHG001

8/16/28

MC 12/05/28

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/15/28
SP-1-K

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

8/16/28

(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84860***84860***

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Monday, May 28, 2012 11:15:07 AM

Item ID: D412-698-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Hinge Panel Automatic Door Opener, LH (Standard)

Stop ***NS2***Start Date: 5/28/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Pick Kit	0.00							
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130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-041

Location: _____

PPP rev: _____

140	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

140

QC

Memo

0.00

Quality Control

12/05/29

ML5 12/05/29
MF 12-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84860

Parent Item: D412-698-041

Parent Item Name: Hinge Panel Automatic Door Opener, LH (Standard)

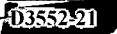



Start Date: 5/28/2012

Required Date: 5/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.08.18 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D3552-21 Door Prop		Manufactured	No			110	Each	5.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		5							
				68168		1							
				73948		4							
 D3622-1 Ball Stud		Manufactured	No			110	Each	38.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST058		38							
				80405		3							
				82072		35							
 D4330-041 Airframe Bracket Assembly, LH		Manufactured	No			110	Each	2.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST198		2							
				73949		2							
 D4330-3 Door Bracket		Manufactured	No			110	Each	7.0000	0	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST197		7							
				73951		7							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 28, 2012 11:15:07 AM

Page 2

Work Order ID: 84860

Parent Item: D412-698-041

Parent Item Name: Hinge Panel Automatic Door Opener, LH (Standard)

Start Date: 5/28/2012

Required Date: 5/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS2104215

Purchased

No

110

Each

1,473.0000

0

1

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

973

108827

8

116105

5

116548

43

117611

18

119109

891

17651

8

NAS1149D0563J

Purchased

No

110

Each

3,392.0000

0

Washer

Location

Loc Qty

Loc Code

ST298

3392

119546

1392

121255

2000

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

5.0 WEIGHT & BALANCE:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-698-041 LH (Standard)	0.23 lb 0.10 kg	-43.63 in -1.11 m	-10.03 in-lb -0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg
D412-698-042 RH (Standard)	0.23 lb 0.10 kg	43.63 in 1.11 m	10.03 in-lb 0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg
D412-698-043 LH (Spacedoor™)	0.23 lb 0.10 kg	-43.63 in -1.11 m	-10.03 in-lb -0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg
D412-698-044 RH (Spacedoor™)	0.23 lb 0.10 kg	43.63 in 1.11 m	10.03 in-lb 0.11 m-kg	86.27 in 2.19 m	19.84 in-lb 0.22 m-kg

6.0 PARTS LIST:

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D412-698-041	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (STANDARD)
	X			D412-698-042	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (STANDARD)
		X		D412-698-043	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (SPACEDOOR™)
			X	D412-698-044	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (SPACEDOOR™)
1	1	1	1	D3552-21	GAS SPRING
1	1	1	1	D3622-1	BALL STUD
1	1	1	1	D4330-041	AIRFRAME BRACKET ASSEMBLY, LH
1	1	1	1	D4330-042	AIRFRAME BRACKET ASSEMBLY, RH
1	1	1	1	D4330-3	DOOR BRACKET
		3	3	80-005-2-8	INSERT
1	1	1	1	MS21042L5	NUT
		3	3	MS27039-1-05	SCREW
		3	3	NAS1149D0332J	WASHER
1	1	1	1	NAS1149D0563J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.01.20
CERT. NO.: SH92-43
ISSUE NO.: 5

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9548	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HINGE DOOR OPENER KIT	NTS
DATE	12.01.17	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	